

Work Order ID 73380

Wednesday, August 31, 2011 1:44:02 PM



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Item ID:	D2228	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bracket Plate					
Start Date:	9/1/2011	Start Qty:	20.00		Cust Item ID:	
Required Date:	9/12/2011	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>MC</u>	Date:	<u>11-01-08</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2228	Rev B								

100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
5652.63	1-Cut as per Dwg D2228 <input checked="" type="checkbox"/> Dwg Rev: <u>B</u> <input type="checkbox"/> Prog Rev: <u>B</u> <input type="checkbox"/> 2- Deburr if necessary								

B11-9-8

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

B11-9-8

50

120	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							

Sulorlog

counts
50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73380

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Item ID:	D2228	Accept		Setup	Start	
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Item Name:	Bracket Plate				Stop	
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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	Chemical Conversion Coat per QSI005 4.1	0.00							
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HandFinish	Memo	0.00							
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Hand Finishing

50X Ø M-L 11/09/12

140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
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Powdercoat	Memo	0.00							
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Powder Coating

START TIME: 3:45 ☐ OVEN TEMPERATURE:

FINISH TIME: 3200F 4:15

150	QC3- Inspect Part Finish	0.00							
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QC	Memo	0.00							
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Quality Control

50X Ø M-L 11/09/12

50 Ø M 11/09/13

M 117745

W/O:		WORK ORDER CHANGES					
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Item ID: D2228

Accept



Setup Start



Revision ID:

Item Name: Bracket Plate

Stop



Start Date: 9/1/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/12/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: 879

0.00



Packaging

Memo

0.00

Packaging

(50x) Sp 11-09-13.

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/13

11/10/13
(50)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 31, 2011 1:43:53 PM

Page 1

Work Order ID: 73380

Parent Item: D2228

Parent Item Name: Bracket Plate



Start Date: 9/1/2011

Required Date: 9/12/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: ☐ B ☐ 00.08.22 ☐ Re-format ☐ EC ☐
IPP C 07.03.20 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M5052H32S.063		Purchased	No			100	sf	77.5000	0.0227	0.454	1.5		
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5052-H32 .063 Sheet



B11-9-8

Location

Loc Qty

Loc Code

MAT022

77.5

114322

77.5

114322

SO

W/O:		WORK ORDER CHANGES					
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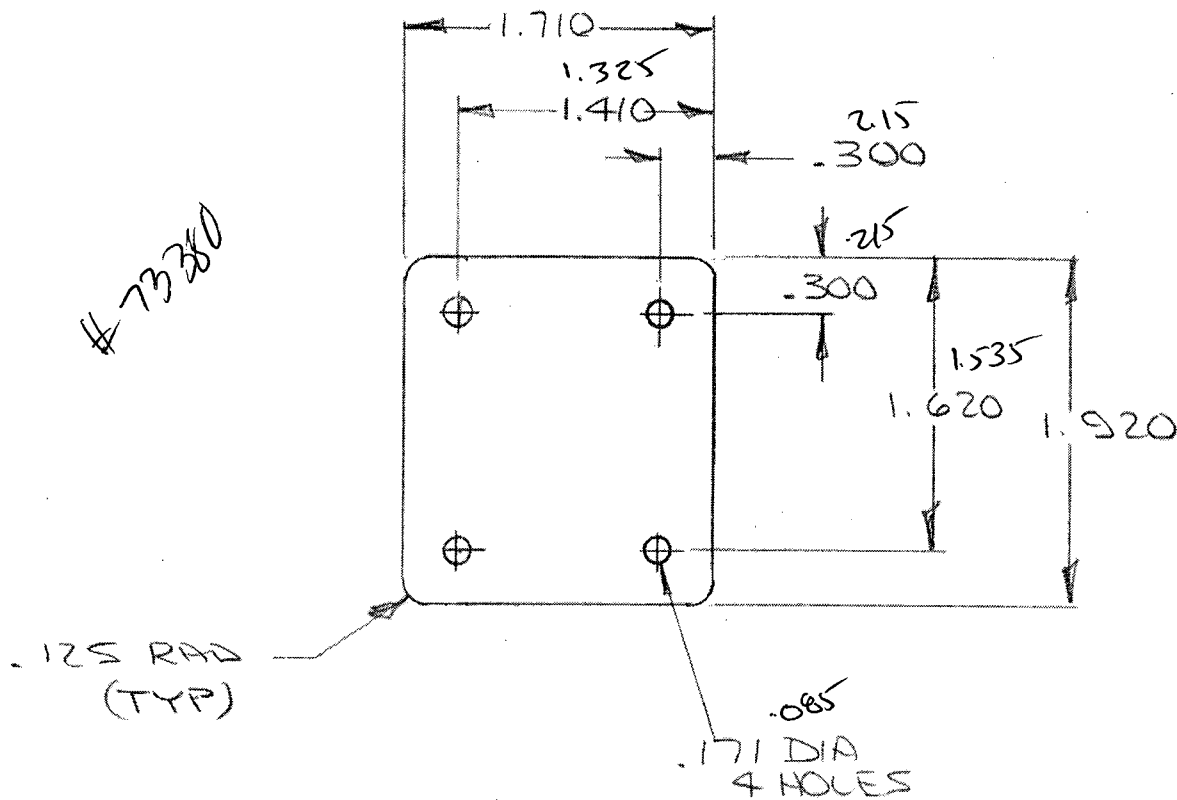
NOTE: Date & initial all entries

DART



DRAWN BRADLEY 94.3.23		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
DESIGN BRADLEY 94.3.27		DRAWING NO. D2228	REV. B
STRESS		TITLE BACKING PLATE	
B	00.09.11	UPDATE FINISH SPEC. # UP	

RELEASED
00.04.12 #



W/O:		WORK ORDER CHANGES					
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